

Work Order ID 67929

Tuesday, April 05, 2011 10:00:03 AM



Page 1

Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-04-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9527

rev A

IIN-D206-559

rev K

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD206-559-011 CHG007

Handwritten signature

Handwritten signature

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Handwritten signature

Handwritten signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-559-011

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Stop

Item Name: Bearpaw

Start Date: 4/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-011
Location: _____

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-08-19
11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:00:09 AM

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Work Order ID: 67929



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM
IPP Rev:D 07-01-02 Was K10007 JLM
IPP Rev:E 08-05-05 up a chg DD verified by:EC
IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			160	Each	480.0000	8				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		480							
				116419		180							
				116704		300							
AN4-20A Bolt		Purchased	No			160	Each	330.0000	8				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		330							
				115936		130							
				116419		200							
AN960JD416 Washer	NAS1149D0463J	Purchased	No			160	Each	0.0000	16	16			

1118384 SP 11/8/17 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67929

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2182B Manufactured No

160 f

362.7002

1.666

1.666



Rubber Cushion



sf

Location

Loc Qty

Loc Code

ST410

362.7002

63413

12.7002

66063

350

✓

(D2182B050) Cut (4) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each

564.0000

8

8



Radius Block



B68942sf

Location

Loc Qty

Loc Code

ST010

564

65757

160

67578

404

D2435 Manufactured No

160 Each

1.0000

2

2



Bearpaw, 206



B69407sf

Location

Loc Qty

Loc Code

ST497

1

59160

1

D2438 Manufactured No

160 Each

44.0000

4

4



Clamp



B67830 sf 11/8/17

Location

Loc Qty

Loc Code

ST456

44

66064

44

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67929

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2529

Manufactured No

160 Each

641.0000 8



Washer

Location

Loc Qty

Loc Code

ST016

641

64127

141

66953

500

MS21042L4

Purchased No

160 Each

3,160.000 8



Nut

Location

Loc Qty

Loc Code

ST300

3160

116188

1160

116823

2000

QS200-M44S

Purchased No

160 Each

27.0000 2



Clamp

Location

Loc Qty

Loc Code

ST450

27

115410

1

115589

14

116857

12

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP